

Date: Wednesday, 9/3/2008 2:36:10 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 41677
 Estimate Number : 10672
 P.O. Number :
 This Issue : 9/3/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D29703
 First Issue : 1/1 Drawing Number : D2970 REV A
 Previous Run : 41677 Type : SMALL /MED FAB Project Number : N/A
 Written By : Drawing Revision : A
 Checked & Approved By : Material :
 Comment : Est: B 01.06.07 Added Material and Tool number SM/EC
 est C 08.09.03 Waterjet EC verified: DD Due Date : 9/10/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2970

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

HB 8-9-15

HB 8-9-15



2.0 M1010S19GA 1010/1025 SHEET .040



Comment: Qty.: 1.3125 sf(s)/Unit Total: 13.1250 sf(s)

1010/1025 SHEET .040

batch: 107906

HB 8-9-15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-9-15

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: DIMENSIONAL CHECK

S 08/09/15 (11)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr and form on brake using DT8178 and DT8261 as per Dwg D2970

HB 08/09/15 (11)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/3/2008 2:36:10 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 41677

Part Number: D29703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/17 (X11)

7.0

POWDER COATING

POWDER COATING



M106442



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:00am

JH 08-09-17

(X11)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. h

08/09/17

(X11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-21

JH

08-09-17

(X11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



W 08-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/08/2008 11:39:07 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	41677	Part Number :	D29703
Estimate Number :	10672	Drawing Number :	D2970 REV A
P.O. Number :		Project Number :	N/A
This Issue :	29/08/2008	Drawing Revision :	A
Prsht Rev. :	NC	Material :	
First Issue :	//	Due Date :	25/09/2008
Previous Run :		Qty:	10
Written By :		Um:	Each
Checked & Approved By :	<u>29.08.29</u>		
Comment :	Est: B 01.06.07 Added Material and Tool number SM/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Laser Cut per Dwg D2970

Material: AISI 1010-1025 or ASTM A36/A366 Series steel 20 gauge (0.040 thick)

Material release note required

water jet

2.0	D29703F	Wearplate
-----	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Wearplate

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr and form on brake using DT8178 and DT8261 as per Dwg D2970

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/08/2008 11:39:07 AM

User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 41677

Part Number: D29703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

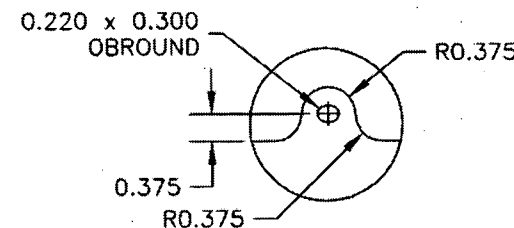
NOTE: Date & initial all entries



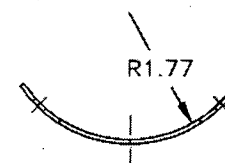
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
RF	RF	BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO.
		D2970
DATE	TITLE	REV. A
00.03.10	WEARPLATE	SHEET 1 OF 1
SCALE	NEW ISSUE	SCALE
A	00.03.10	1:10

RELEASED
00.05.11

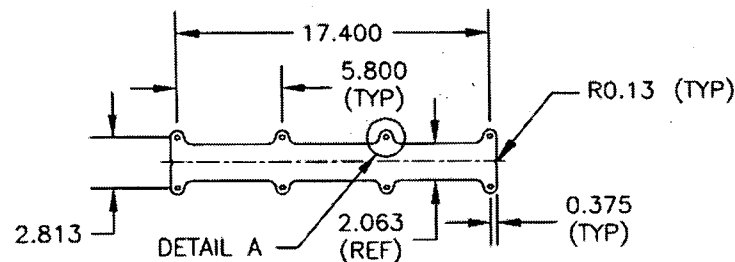
DETAIL A
SCALE 2:5



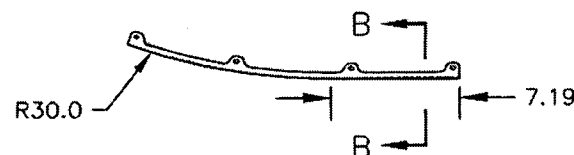
SECTION B-B
SCALE 2:5



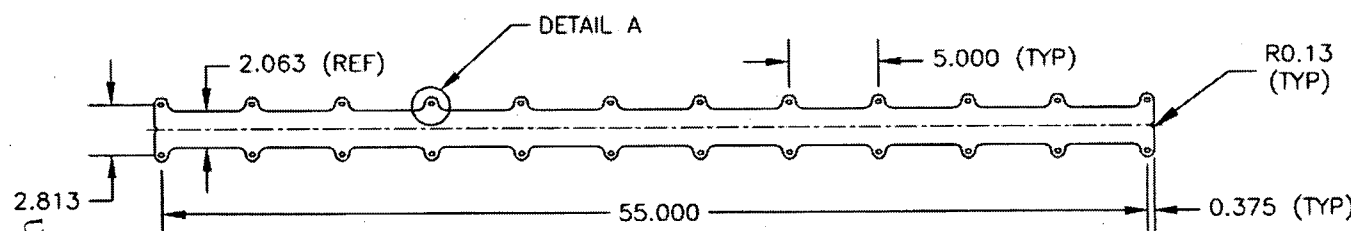
D2970-1 FLAT PATTERN



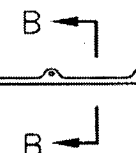
D2970-1 BENDING DETAIL



D2970-3 FLAT PATTERN



D2970-3 BENDING DETAIL



BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
WITHOUT NOTICE

DART AEROSPACE LTD	Work Order: 41677
Description: WEAR PLATE	Part Number: D2970-3
Inspection Dwg: D2970-3, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

x

Prototype

[illegible]

Measured by:	UR
Date:	8-9-15

Audited by:	o
Date:	08/06/15

Prototype Approval:	1
Date:	1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	